

Work Order ID 51918

Wednesday, September 09, 2009 11:31:25 A



Page 1

Item ID: D3537-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Wearpad

Start Date: 9/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

MP

Date: 09-9-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

304
.003

1-Cut as per Dwg D3537 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-Deburr if necessary

HB 9-9-23

53

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 9-9-23

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

27802/09/23

Carfer
HB

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

53

Ø

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. □2-
Identify as D3537-1

SB 09/09/25

140

0.00



Large Fab

SP 09.09.30 (53X)

Large Fab

Memo

0.00

Large Fab

Qty Description Batch □ A/R 2059B Hardcoat
H 109893 H 12222 □1-Weld as per Dwg D3537 using Jig DT 8210 □2-Remove any
weld that penetrated through Wearpad if necessary

150

0.00



QC10- Inspect visual per QSI004- ground welds

2) S or 10/130

QC

Memo

0.00






Quality Control

counters
(53) f



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Item ID: D3537-1 Accept  Setup Start 
Revision ID: C Stop 
Item Name: Wearpad
Start Date: 9/10/2009 Start Qty: 40.00  Cust Item ID:
Required Date: 9/18/2009 Req'd Qty: 40.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ 509/09/10			center X53	φ		
170  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 11109091 Memo START TIME: 1:45pm □ OVEN TEMPERATURE: 2:15pm FINISH TIME: 320°F	0.00 0.00	⇒ 11 09/10/09			X53	φ		
180  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	18/09/10-2			53			

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Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Packaging	Identify as per dwg & Stock Location: <u>FP-17</u> Memo	0.00 0.00	<u>09/10/02</u>			<u>(X53)</u>	<u>0</u>		
200 QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
Quality Control									

09/10/05
09-10-2

Picklist Print

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Page 1

Work Order ID: 51918



Parent Item: D3537-1RevC



Parent Item Name: Wearpad

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	261.2310	4.4632	5.9137		



304/316 Sheet .063

13 9-9-23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

261.2309737

106860

16.018

111924

33.0549737

112290

36.8947

112442

79.2633

112567

96

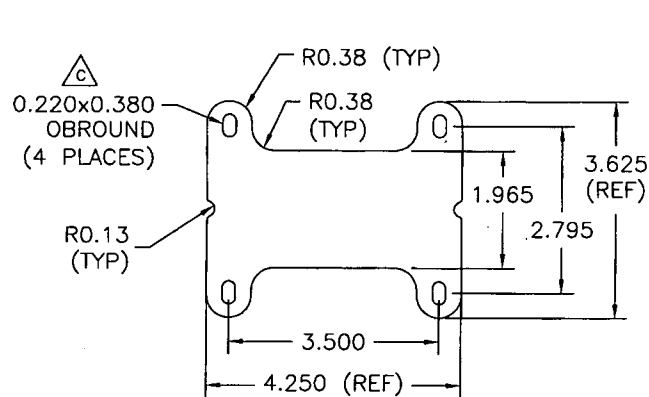
112290

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

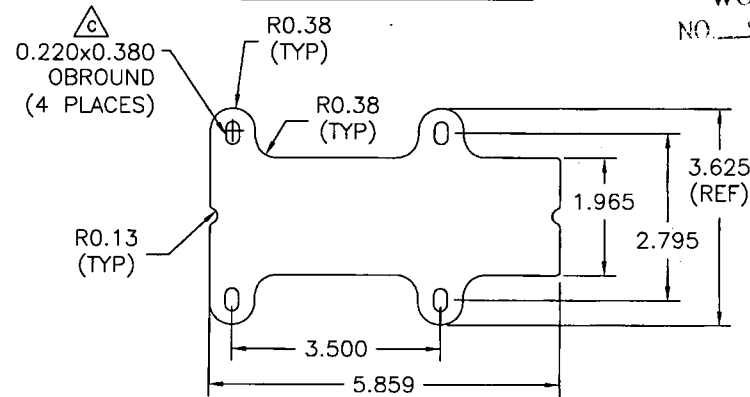
WITHOUT NOTICE
WORK ORDER

NO. 31918

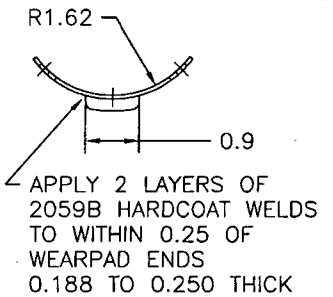
D3537-1F FLAT PATTERN



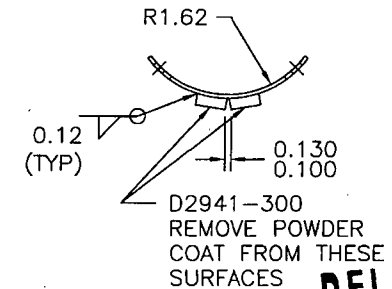
D3537-3F FLAT PATTERN



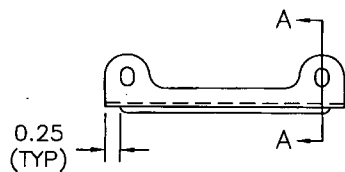
SECTION A-A



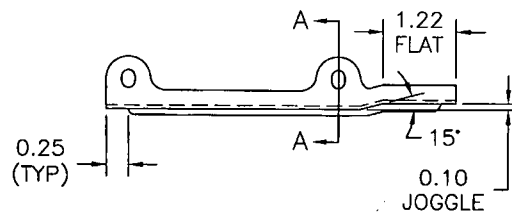
SECTION B-B



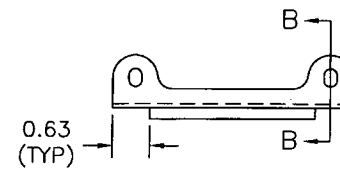
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



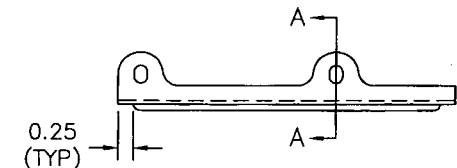
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

RELEASED
07.05.08 PH
PER ELN
962